

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3646-1 PAR #: _____ Fault Category: Small Feb. NCR: Yes No DQA: [Signature] Date: 05.05.10
 Resolution: Scrap. Disposition: Scrap. QA: N/C Closed: [Signature] Date: 05.08.10

NCR: <u>51451</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/6/27	110	Durking inspection it was found that the 65° angle was wrong measuring 25° about. R.C. Duty is still incorrect (No it's not) Angle was not close to duty. R.C.: Lack of Attention.	<u>[Signature]</u> 05/04/2	Scrap and destroy Qty 5 or save for a shorter study re-stock for hcl-procs. B# <u>M112187</u>	<u>M.D.</u> 09/08/27	<u>[Signature]</u> 09/08/27	<u>[Signature]</u> 05/04/2	<u>[Signature]</u> 09/08/27
			<u>[Signature]</u> 05/04/2	Ensure to correctly understand the duty... if not ask "what's up"				

NOTE: Date & initial all entries

Work Order ID 51451

August 24, 2009 3:48:26 PM



Page 2

Item ID: D3646-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Arm

Start Date: 08/24/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 08/25/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M109691

3:00pm

3200x

3:30pm

0.00

JH 09/09/02

(X5)

Ø

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BK 09-09-3

(5)

150



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

(149/4) (5)

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Work Order ID 51451

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Page 3

Item ID: D3646-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Arm

Start Date: 08/24/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 08/25/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/08
mf 09-09-08

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Picklist Print

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Page 1

Work Order ID: 51451



Parent Item: D3646-1RevB



Parent Item Name: Arm

Start Date: 08/24/2009

Required Date: 08/25/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	283.0441	10.4211			

304 RD Tube .500 x .035W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	283.0441097	
108250	2.23	
111097	24.687936	
111704	31.6682737	
112187	224.4579	✓

M112187
m-h 09/08/26

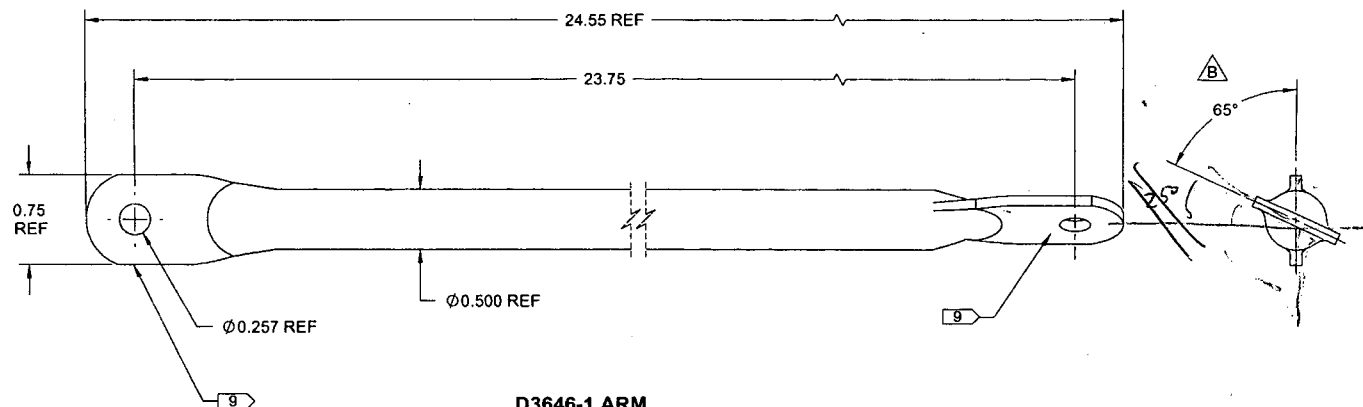
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D3646-1 ARM

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE $\phi 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.38 lbs
- 8) MAKE PER TEMPLATE DT8958
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

51451
RELEASED
09/06/04

B	REFORMAT DWG, ANGLE 65° WAS 45° (ZN C3-1), ADD IDENTIFICATION TAG (ZN A8-1, A8-2)	CP	09.06.04
A	NEW ISSUE	MB	07.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3646** REV. B
SHEET 1 OF 2
TITLE **ARM** SCALE NTS

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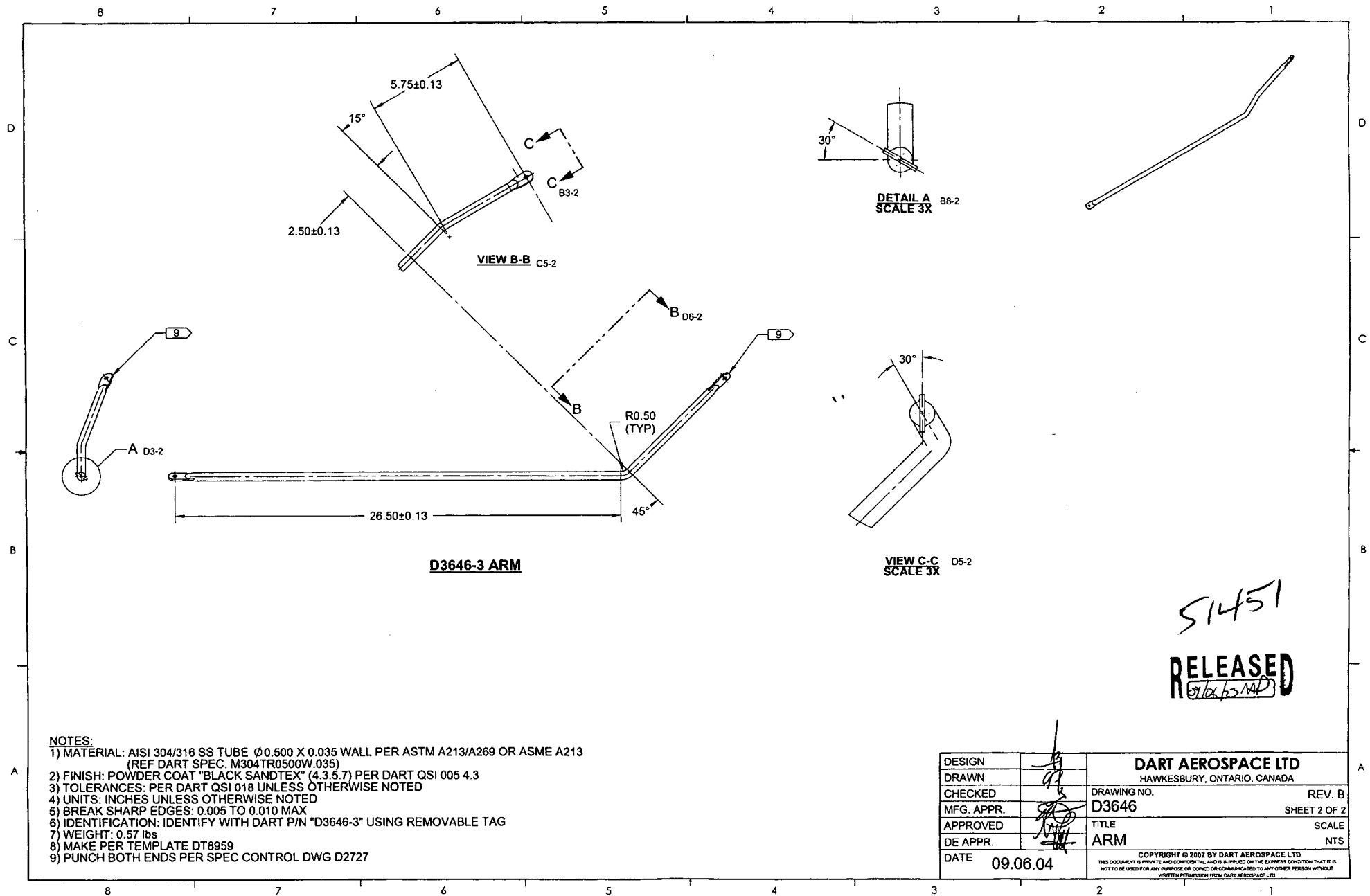
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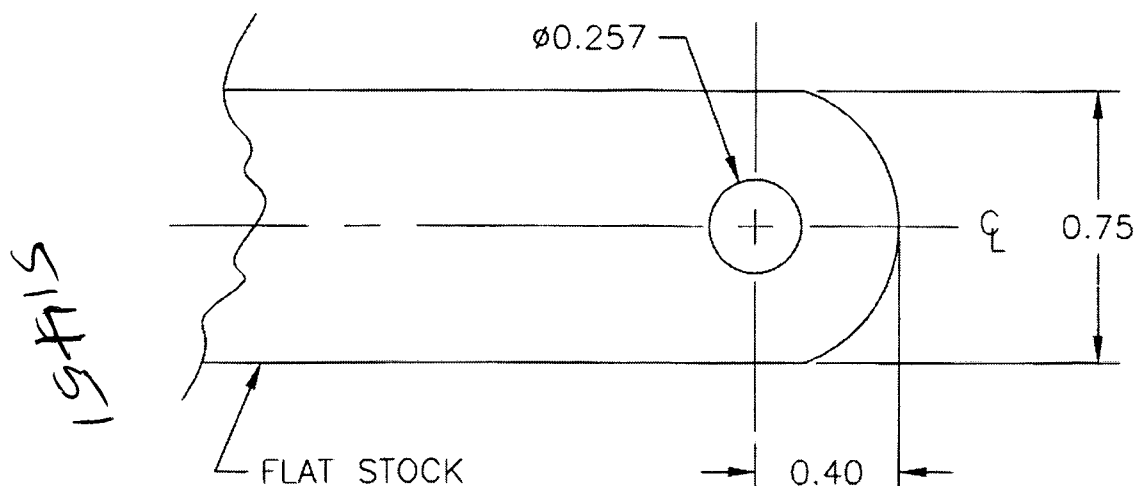
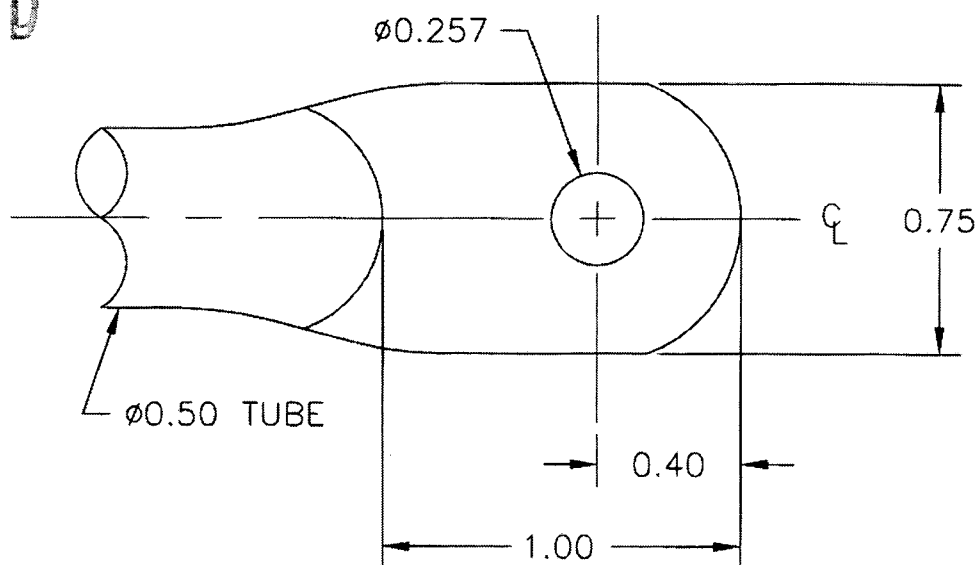
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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DM</i>	APPROVED <i>CA</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	A1 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI DIB UNLESS OTHERWISE NOTED.

